

Work Order ID 157947

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Page 1

Item ID: D5162-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Structure Assembly
Start Date: 3/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/31/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: mc Date: 17-3-6 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3016	(DEO) A1								
D3017	C								
D5162	A								
D5189	A								

105 Pick Kit 0.00

105

Packaging Memo 0.05

Packaging

1 Q 17-3-10110 Weld per dwg A/R 4130 rod Batch: M127925 0.00***110***

Large Fab Memo 0.17

Large Fab

FABRICATE D5189-041 AS PER DWG AND BY USING DT8622.

DO NOT OPEN HOLES TO SIZE, IT WILL BE OPEN UPON FINAL ASSEMBLY.

ONLY WELD STUD D4667-041 TO TUBE. END CAP WILL BE WELDED AFTER OPENING HOLES IN TUBE.

1 Q 17-3-10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Weld per dwg A/R 4130 rod Batch: <u>M127925</u>	0.00							
120									
Large Fab	Memo	0.17							
Large Fab	FABRICATE (2) D3016-041 AS PER DWG.								
	WELD ASSEMBLY USING DT8597 WELD JIG.								
	DO NOT DRILL HOLES AS THEY WILL BE TRANSFER DRILL AT FUTHER STEP.								
	DO NOT WELD GUSSETS AND BRACKET THEY WILL BE WELDED AT A FUTHER STEP.								

1 EL 17-3-10

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Quality Control

1 Q 17-3-10

① 17.03.13 ①

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1- USE DT10132 AND DT10133 TO TRANSFER DRILL HOLES IN SEAT PAN AND SEAT BRACE.

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Quality Control

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175 *175* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							① 17-03-13 PD FAI attach for new tooling.
180 *180* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo CHEMICAL CONVERSION SEAT PANEL D3022-1 AND BACK PANEL D3023-1 AS PER DWG	0.00 0.15							(X1) 2017/03/13 BEB
190 *190* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.00							1x 17/03/14 DAS 36 9-88

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Small Fab	Memo (TO FABRICATE D5162-051) ASSEMBLE D3023-1 PANEL TO D3017-041 BACK FRAME AS PER DWG D5162-051	0.00 0.33				<u>1X</u>			<u>17/03/17</u> DAS 36 9-89
210 *210* QC	QC5- Inspect part completeness to step on W/O	0.00				<u>1</u>			<u>17-03-17</u> DAS 38 9-89 MAR 14 2017
220 *220* Powdercoat	Grey Sandtex(Ref 4.3.5.6) per OSI005 4.3 M 134 854.	0.00				<u>1</u>			<u>17-03-17</u> 3433
Powder Coating	Memo POWDER COAT ALL INDIVIDUAL PARTS START TIME: <u>10:20</u> OVEN TEMPERATURE: <u>300</u> FINISH TIME: <u>10:50</u>	0.05							

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location <i>u/o</i>	0.00							
260									
Packaging	Memo <i>158352</i>	0.00				<i>1X</i>			<i>12/03/21</i>
Packaging									
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.02							<i>17/3/21</i>
Quality Control									<i>mf</i> <i>17-3-21</i>

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Required Qty: 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA002	6	
154489	6	

Picklist Print

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

D3016-7

Manufactured No

105

Each

24.0000

4

4

D3016-7

Tube

**

Q 17-3-7

Location

Loc Qty

Loc Code

WA001

12

154490

12

WA002

12

155483

12

D3016-9

Manufactured No

105

Each

6.0000

2

2

D3016-9

Saddle

**

Q 17-3-7

Location

Loc Qty

Loc Code

WA001

6

154491

6

D5190-1

Manufactured No

110

Each

6.0000

1

1

D5190-1

Armrest Fitting

**

Q 17-3-7

Location

Loc Qty

Loc Code

WA003

6

152308

6

D5190-3

Manufactured No

110

Each

24.0000

1

1

D5190-3

Weld Pin

**

Q 17-3-7

Location

Loc Qty

Loc Code

WA002

24

154143

24

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

M4130NT0.750W.049

Purchased

No

105

f

50.9990

13.8

14.52632

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

14.52632 EL 17-3-10

Location

Loc Qty

Loc Code

MAT033

50.999

m136323

3.166

m136760

47.833

13.85

D4667-041

Manufactured

No

110

Each

7.0000

1

1

D4667-041

Armrest Stud Assembly

**

EL 17-3-7

Location

Loc Qty

Loc Code

WA001

7

154903

7

D3020-1

Manufactured

No

120

Each

14.0000

4

4

D3020-1

Fitting

**

EL 17-3-7

Location

Loc Qty

Loc Code

WA001

5

154492

5

WA002

9

152262

9

D3017-7

Manufactured

No

130

Each

21.0000

3

3

D3017-7

Lug

**

EL 17-3-9

Location

Loc Qty

Loc Code

WA002

21

154540

5

155291

6

156836

10

3

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

D3023-1 Manufactured No

130 Each 2.0000 1 1

D3023-1

Back Panel

**

EL 17-3-10

Location	Loc Qty	Loc Code
WA	1	
154494	1	
WA001	1	
153973	1	

WA

1

154494

1

WA001

1

153973

1

M4130NT0.750W.083 Purchased No

105 f 24.1430 2.5 2.631579

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

EL 17-3-10

Location	Loc Qty	Loc Code
MAT032	24.143	
m135242	4.56	
m136569	19.583	

MAT032

24.143

m135242

4.56

m136569

19.583

D3022-1 Manufactured No

150 Each 3.0000 1 1

D3022-1

Seat Pan

**

EL 17-3-10

Location	Loc Qty	Loc Code
WA001	3	
155301	1	
155302	1	
156862	1	

WA001

3

155301

1

155302

1

156862

1

D3016-15 Manufactured No

165 Each 6.0000 2 2

D3016-15

Gusset

**

EL 17-3-10

Location	Loc Qty	Loc Code
WA002	6	
119895	2	
148096	2	
155243	2	

WA002

6

119895

2

148096

2

155243

2

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

D3016-13 Manufactured No

165 Each 4.0000 2 2

D3016-13

**

Bracket

17-3-9

Location

Loc Qty

Loc Code

WA002

4

152206

4

2

D3016-17 Manufactured No

165 Each 8.0000 2 2

D3016-17

**

Gusset

17-3-10

Location

Loc Qty

Loc Code

WA002

8

138268

8

2

D3017-11 Manufactured No

165 Each 19.0000 4 4

D3017-11

**

Cap

17-3-7

Location

Loc Qty

Loc Code

WA001

19

142889

9

154516

2

155249

8

MS20600-AD4W2 Purchased No

200 Each 284.0000 46 46

MS20600-AD4W2

**

Rivet

*68-6
96
DAS*

*17/03/14
DAS
36
89*

Location

Loc Qty

Loc Code

CCK005

120

m136579

120

GA

124

m126475

6

m136047

118

ST308

40

m134762

40

40

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

AN4-6A

Purchased

No

240

Each

689.0000

1

1

AN4-6A

BOLT

**

MAR 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

over003

400

M136554

200

M136851

200

ST345

289

M135945

91

M136263

198

NAS43DD4-16FC

Purchased

No

240

Each

62.0000

2

2

NAS43DD4-16FC

Spacer

**

MAR 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST550

62

m135774

62

AN4-4A

Purchased

No

240

Each

37.0000

1

1

AN4-4A

BOLT

**

MAR 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST346

37

m129390

37

D5159-043

Manufactured

No

105

Each

3.0000

1

1

D5159-043

Seat Back Brace Assembly

**

EL 17-3-10

Location

Loc Qty

Loc Code

ST358

3

154057

2

154930

1

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-20

Purchased

No

240

Each

34.0000

4

4

MS27039-4-20

**

MAR 20 2017

DAS

Screw

Location

Loc Qty

Loc Code

ST279

34

m135056

34

MS20600-AD4W4

Purchased

No

240

Each

301.0000

4

4

MS20600-AD4W4

**

MAR 20 2017

DAS

Rivet

Location

Loc Qty

Loc Code

CCK004

11

M135704

11

ST308

6

M133990

6

WA003

284

M135442

204

M136295

80

MS27039-1-19

Purchased

No

240

Each

178.0000

4

4

MS27039-1-19

**

MAR 20 2017

DAS

Screw

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

98

m136648

98

D3024-1

Manufactured

No

240

Each

18.0000

3

3

D3024-1

**

MAR 20 2017

DAS

Spacer

Location

Loc Qty

Loc Code

ST015

18

152203

18

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-17

Purchased

No

240

Each

157.0000

1

1

MS27039-1-17

Screw (601.1954)

**

MAR 20 2017
DAS
6
9-89

Location

Loc Qty

Loc Code

GA

150

m127831

150

ST280

7

120142

7

MS24693-S49

Purchased

No

240

Each

205.0000

4

4

MS24693-S49

Screw

**

17/03/21
DAS
36
9-89

Location

Loc Qty

Loc Code

ST286

205

m130835

205

NAS1149D0332J

Purchased

No

240

Each

1,100.000

30

30

NAS1149D0332.J

Washer

**

MAR 20 2017
DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

12

m134848

12

GA

610

m134848

10

m136643

600

ST264

478

m136015

478

30

DAS
36
9-89

MS20600-AD4W3

M129795

CX

17/03/14
DAS
36
9-89

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W5

Purchased

No

240

Each

258.0000

8

8

MS20600-AD4W5

**

Blind Rivet

Location

Loc Qty

Loc Code

ST308

121

m132769

121

WA004

137

m131618

134

m132640

3

MS21042L3

Purchased

No

240

Each

1,473.000

17

17

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

264

m134360

102

M136665

162

OVER007

300

m134360

0

M136665

300

ST303

809

M136554

500

M136838

309

NAS1149D0432J

Purchased

No

240

Each

473.0000

17

17

NAS1149D0432J

**

WASHER

Location

Loc Qty

Loc Code

GA

24

m131026

24

ST264

449

m134676

449

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D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

D5159-041 Manufactured No

105 Each 4.0000 1 1

D5159-041

**

Seat Back Brace Assembly

17-3-10

Location

Loc Qty

Loc Code

ST358

4

154942

2

157015

2

AN4-14A Purchased No

240 Each 244.0000 2 2

AN4-14A

**

Bolt

MAR 20 2017 6 9-89

Location

Loc Qty

Loc Code

FG

5

122141

5

over003

200

M136855

200

ST344

39

M136554

39

D3031-1 Manufactured No

240 Each 8.0000 2 2

D3031-1

**

Loop

MAR 20 2017 6 9-89

Location

Loc Qty

Loc Code

GA

8

134318

2

153946

6

17/03/21
DAS
36
9-89

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D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

AN3-12A

Purchased

No

240

Each

282.0000

3

3

AN3-12A

Bolt

**

Location

Loc Qty

Loc Code

over003

206

153854

206

ST349

76

m135603

76

MS21042L4

Purchased

No

240

Each

1,892.000

8

8

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

FP001

18

m133363

18

GA

187

m135058

187

OVER007

500

m136450

500

ST303

1187

m136648

187

m136838

1000

D2199-31

Manufactured

No

105

Each

2.0000

1

1

D2199-31

Strut Details

**

Location

Loc Qty

Loc Code

ST352

2

148110

2

MAR 20 2017
DAS 6
3-89

MAR 20 2017
DAS 6
3-89

Q 17-3-10

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-20

Purchased

No

240

Each

99.0000

2

2

MS27039-1-20

Screw

**

MAR 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST280

99

m136554

99

2

MS27039-4-21

Purchased

No

240

Each

63.0000

2

2

MS27039-4-21

Screw

**

MAR 20 2017

DAS
6
9-89

Location

Loc Qty

Loc Code

ST279

63

m132803

3

2

m135774

60

MS27039-1-18

Purchased

No

240

Each

1,643.000

3

3

MS27039-1-18

Screw

**

MAR 20 2017

DAS
6
89

Location

Loc Qty

Loc Code

GA

245

123522

45

124326

200

over006

1200

124326

1200

ST280

198

124326

198

3

D5159-045

Manufactured

No

105

Each

3.0000

1

1

D5159-045

Seat Rib Assembly

**

2/7-3-10

Location

Loc Qty

Loc Code

ST358

3

154798

1

154941

2

1

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Parent Item: D5162-041

D5162-041

Parent Item Name: Seat Structure Assembly

Start Date: 3/6/2017

Required Date: 3/31/2017

Start Qty: 1.00

Required Qty: 1.00

AN970-4

Purchased

No

240

Each

167.0000

1

1

AN970-4

MAR 20 2017

Washer

Location

Loc Qty

Loc Code

ST260a

50

m135390

0

m136406

50

ST321

117

m136044

17

m136787

50

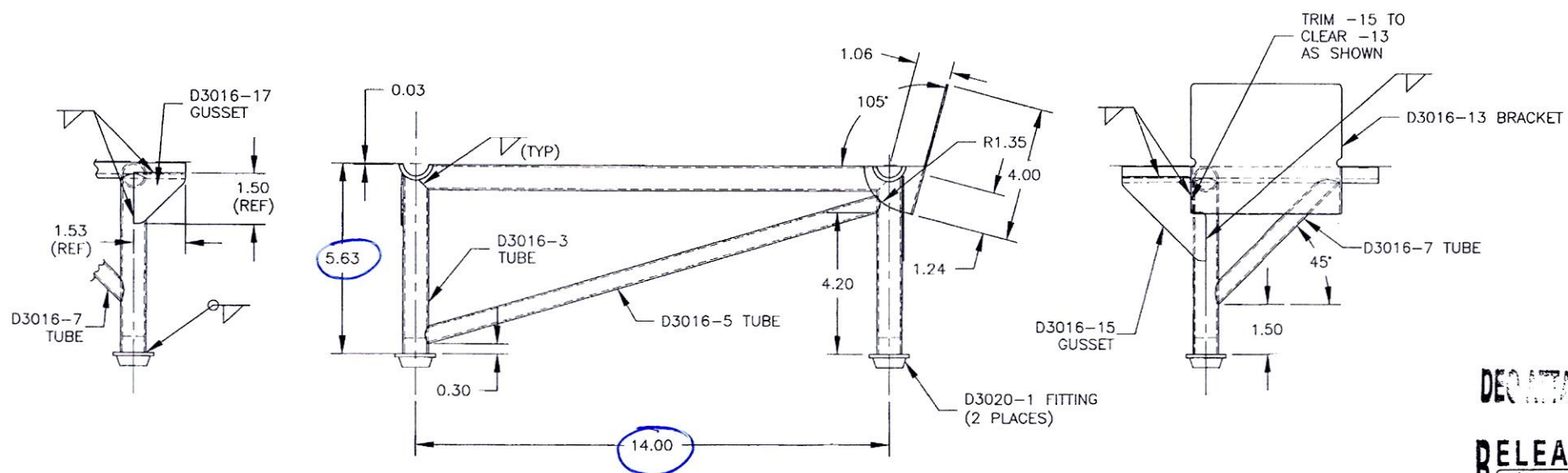
m136983

50

DAS
6
9-80

Technical drawing of a D3016-1 TUBE assembly. The drawing shows a horizontal tube (D3016-1 TUBE) connected to two vertical saddles (D3016-9 SADDLE and D3016-11 SADDLE). Dimensions and reference values are indicated:

- Left saddle (D3016-9 SADDLE):
 - Overall height: 6.65 (REF)
 - Height from centerline to top: 5.13
- Tube (D3016-1 TUBE):
 - Height from centerline to top: 5.13
- Right saddle (D3016-11 SADDLE):
 - Height from centerline to top: 3.33 (REF)
 - Height from centerline to bottom: 4.50 (REF)
 - Overall height: 7.63 (REF)



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RELEASED
01-05-30

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DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY			SCALE 1:3